



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.8511

Job Sheet 205011



Part No: 647.8511

Job Qty: 24 pcs

Part Name: Insert



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 3/6/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 16-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	24 pcs	3/6/20	3/6/20	1.00	19.12	Doosan - 1	
110	QC 2	24 pcs	3/6/20	3/6/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S248640



Part: 647.8511

Job No: 205011

Serial No/Batch: S248640

Revision: Rev NC

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/20/20

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120 QC 8	24 pcs	3/6/20	0.00	0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	MD / J.E.C. 20-01-21
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
122 Outsource - 17 - Passivate	24 pcs	3/6/20			GRO002-VC	7 JAN 2020-01-23
123 Packaging 2-1 - Receive - B4B	24 pcs	3/6/20	0.00	0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	JAN 2 8 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	

124 QC 6	24 pcs	3/6/20	0.00	0.00	Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
					QC 6 - 9	DAS
					QC 6 - 68	JAN 29 2020 68
					QC 6 - 61	9-89
					QC 6 - 40	
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	24 pcs	3/6/20	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	DAS
					Packaging 3 - 24 - B4B	34
					Packaging 3 - 25 - B4B	9-89
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	24 pcs	3/6/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - (Doosan Lathe) 1-Turn as per Folio FB511 & Dwg 647.8500 Folio Rev: NA Dwg Rev: NA 2-Debur
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 122 - -Issue P/O to Groupe Altech: P/O 45070 -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of
 Conformity is required

- 123 - (Receive & Inspect for Damage & Mat'l Certs)
 124 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.625	303 Round Bar 0.625"	.9600 ft (.04 ea)	100-Doosan - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R0.625	1	39	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.016Inches ± 0.005	0.021 0.011	.011	
2	Insert	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
3	Insert	0.020Inches ± 0.010	0.030 0.010	.015	Radius
4	Insert	0.210Inches + 0.005 - 0.001	0.215 0.209	.211	Diameter
5	Insert	0.300Inches ± 0.010	0.310 0.290	.301	Diameter
6	Insert	0.350Inches ± 0.010	0.360 0.340	.343	Diameter
7	Insert	0.060Inches ± 0.005	0.065 0.055	.056	
8	Insert	0.374Inches ± 0.005	0.379 0.369	.375	
9	Insert	0.560Inches + 0.000 - 0.010	0.560 0.550	.555	
10	Insert	0.367Inches ± 0.005	0.372 0.362	.369	
11	Insert	0.097Inches ± 0.005	0.102 0.092	.095	Diameter
12	Insert	0.075Inches ± 0.005	0.080 0.070	.074	Depth

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045670



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045670

PO Date: 1/23/20

Due Date: 1/31/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-01-24

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206035	647.8511	647.8500 Rev NC	Insert -Issue P/O to Groupe Altech -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed - X11		1/30/20	11 pcs	0 pcs	11 pcs	\$0.59/pcs	\$6.49
							JAN 28 2020					
	205011				Firmed - X30		1/31/20	30 pcs	0 pcs	30 pcs	\$0.59/pcs	\$17.70
Sub Total:								41	0	41		\$24.19
2	205010	647.8510	647.8500 Rev NC	Insert ISSUE PO -Passivate, MIL-S-5002 TYPE 6 AS PER DWG (MPP-172) - Certificate of Conformity is required	Firmed - X340		1/31/20	340 pcs	0 pcs	340 pcs	\$0.59/pcs	\$200.60
							JAN 28 2020					
3	205012	647.8512	647.8500 Rev NC	Insert -Issue P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed - X20		1/31/20	20 pcs	0 pcs	20 pcs	\$0.62/pcs	\$12.40
							JAN 28 2020					
Grand Total:												\$237.19

Guérin



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER

POHB045670



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/24/20 8:27 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025715-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

025715- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expedition Ship date		Crée Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Jan-2020		Jigar Patel		POHB045670				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir / Back Order
1	647.8511 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG	PASSIVATION CH	11	11	0	0	0
2	647.8511 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG	PASSIVATION CH	30	30	0	0	0
3	647.8510 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG (MPP-172)	PASSIVATION CH	340	340	0	0	0
4	647.8512 Rev.NC	647.8500 PASSIVATION NITRIC #1/ DICHROMATE [PASSIVATION NITRIC #1/ DICHROMATE] PASSIVATE, MIL-S-5002 TYPE - 6 AS PER DWG (MPP-172)	PASSIVATION CH	20	20	0	0	0

RECEIVED

JAN 27 2020

DART AEROSPACE LTD.

DAS
68
9-89

 DAS
 68
 9-89

RECEIVED

JAN 27 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.